

Date: Thursday, 29/05/2008 3:17:36 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STRUT ASSEMBLY		
Job Number	: 39583			Part Number	: D23241		
Estimate Number	: 10732			Drawing Number	: D2324 REV. C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 29/05/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 06/06/2008	Qty:	20
Previous Run	: 39152			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JYL 08.5.29</u>						
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	39583A	STOP	
		Comment: Sub-Component STOP D2324-3 B <u>39152A</u>	<u>EP08/05/30</u>
2.0	39583B	STRAP	
		Comment: Sub-Component STRAP D2324-5 B <u>39152B</u>	<u>EP08/05/30</u>
3.0	AN312A	Bolt	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Bolt <u>M106605</u>	<u>EP08/05/30</u>
4.0	AN960JD10	Washer	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s) Washer <u>M108077</u>	<u>EP08/05/30</u>
5.0	MS21042L3	Nut	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Nut <u>M107644</u>	<u>EP08/05/30</u>

Dart Aerospace Ltd.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D23241.

08/05/08 (20)

7.0 QC5

INSPECT WORK TO CURRENT STEP



*Saw no scratches.

S 08/05/08 (20)

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



m107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 12:50

OVEN TEMPERATURE: 320°

FINISH TIME: 1:20

FL 08/06/02

(20)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BL 08-06-02

(20)

Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



SDo.3 P. JSH (20)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/03 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/06/03

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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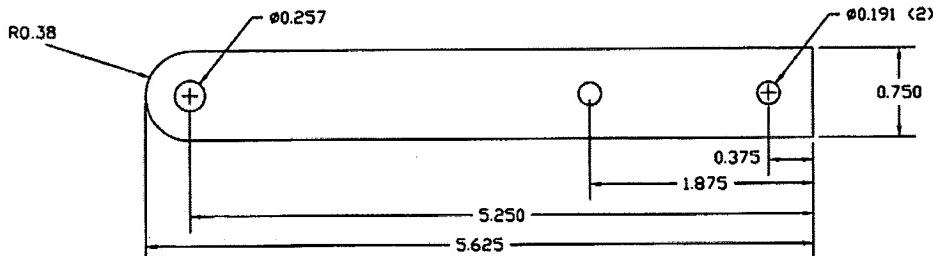
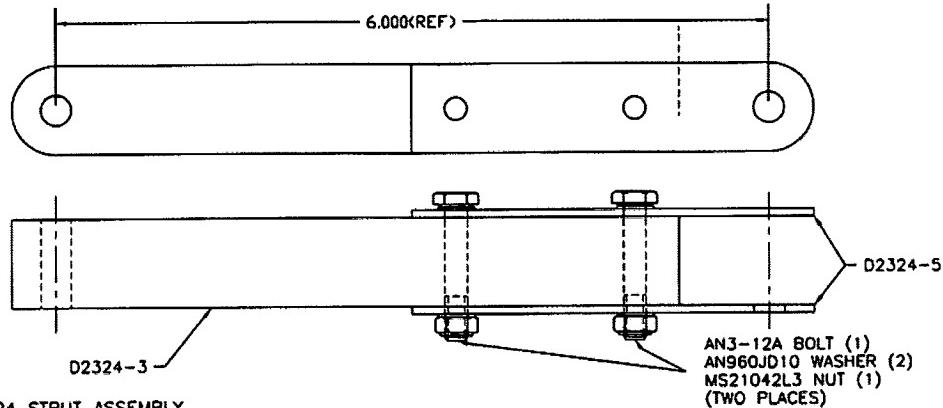
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART

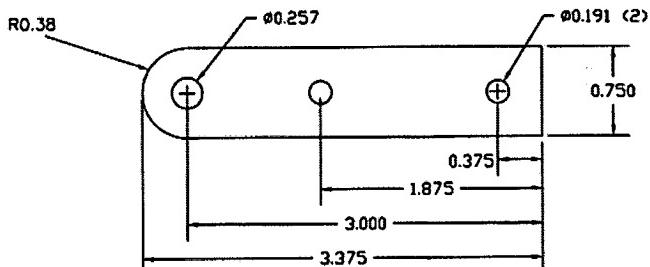
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE STRUT	REV. C SHEET 1 OF 1

RELEASED

04.12.16 *[Signature]*

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39583

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries